

Work Order ID 111177

January-09-14 12:38:29 PM

111177

Rev 8 5/14/01/24

PRELIMINARY ISSUE

Page 1

Item ID: D4635-042

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Ceiling Panel Assembly, RH

Stop

NS2

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-01-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DAS

D4635

PD2 E 8/14/01

PD2 E

27
9-89

per EEN 14-509

0.00

0.00

0.00

0.00

100

100

HandThermo

Hand Finishing Thermoforming

Memo

Pick Kit

1X

14*1-23

DAS
26
9-89

110

110

Small Fab

Small Fab

Memo

1- Assemble as per Dwg D4635-042

2-Install speakers

3- Install Air valves

4-Install Wiring Harness

5-Install wiring harness

1X

14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111177

January-09-14 12:38:29 PM

111177

Page 2

Item ID: D4635-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00 DAS

120

27

QC

Memo

0.00 9-89

Quality Control

141.23

1
inspect as per
Dwg PEI

130

Identify as per dwg & Stock Location: _____

0.00

130

0.00

Packaging

Memo

Packaging

Thermo

mcs

140

QC21- Final Inspection - Work Order Release

0.00

140

0.00

QC

Memo

Quality Control

mcs 14-01-24

POSITIVE RECALL
EFFECTIVE 14/01/24 AUTH h
RELEASED 5 DATE 14/01/24

Release Dwg
Rev E
DAS
27
9-89
14/1/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Thursday, January 23, 2014 8:26:25 AM

Page 1

Work Order ID: 111177

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
DL IPP Rev B 12/11/08 Doc Release
IPP Rev C Dwg. Update 13/07/09 DL verf:DD
Rev D Dwg. Update 14/01/20 DL IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-142		Manufactured	No			100	Each	2.0000	1	1			DAS 26 9-89
Fwd Ceiling Replacement Panel Assembly, RH													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				prelim		2							
				111201		1							
				111204		1							
D4646-1		Manufactured	No			100	Each	84.0000	2	2			DAS 26 9-89
Plenum Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST116		84							
				103832		66							
				92968		6							
				95779		12							
D4652-1		Manufactured	No			100	Each	215.0000	2	2			DAS 26 9-89
Air Valve, 1.16 Id Disk Type													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				prelim		24							
				111316		12							
				111317		12							
				ST099		191							
				111311		191							
D4655-1		Manufactured	No			100	Each	90.0000	2	2			DAS 26 9-89
Speaker													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST478		48							
				103939		48							
				ST483		42							
				93061		42							

14/01/23

DL

24

DL 14/01/23

14-1-23.

2x

Picklist Print

Thursday, January 23, 2014 8:26:26 AM

Page 2

Work Order ID: 111177

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4708-9	Manufactured	No	100	Each	55.0000	2	2	DAS 26 9-89
Lanyard								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST119	55	
111242	49	
93919	6	

2x	DAS 26 9-89
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D4728-042	Manufactured	No	100	Each	0.0000	1		DAS 26 9-89
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RH Cabin Speaker #1

D4728-044	Manufactured	No	100	Each	1.0000	1		DAS 26 9-89
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RH Cabin Speaker #2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST121	1	
96225	1	

2	2	DAS 26 9-89
---	---	-------------------

D4743-1	Manufactured	No	100	Each	30.0000	2	2	DAS 26 9-89
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Speaker Grill

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST122	30	
111220	30	

2x	DAS 26 9-89
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MS21044-N08	Purchased	No	100	Each	265.0000	8	8	DAS 26 9-89
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Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST315	265	
123741	115	
m127813	150	

8x	DAS 26 9-89
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MS21919-WDG8	Purchased	No	100	Each	82.0000	6	6	DAS 26 9-89
--------------	-----------	----	-----	------	---------	---	---	-------------------

Clamp

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST322	82	
m127305	12	
m127831	40	
m127916	30	

14-1-23.	DAS 26 9-89
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6x	DAS 26 9-89
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Thursday, January 23, 2014 8:26:26 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, January 23, 2014 8:26:26 AM

Page 3

Work Order ID: 111177

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS24693-BB51

Purchased

No

100

Each

528.0000

8

8

DAS

Screw

26

9-89

Location

Loc Qty

Loc Code

ST299

528

124704

28

m127916

500

NAS1149DN832J

Purchased

No

100

Each

3,136.0000

8

8

DAS

26

9-89

Washer

14-1-23

Location

Loc Qty

Loc Code

ST293

1000

M127813

1000

st510

376

124555

376

ST510a

1760

M126319

760

M127255

1000

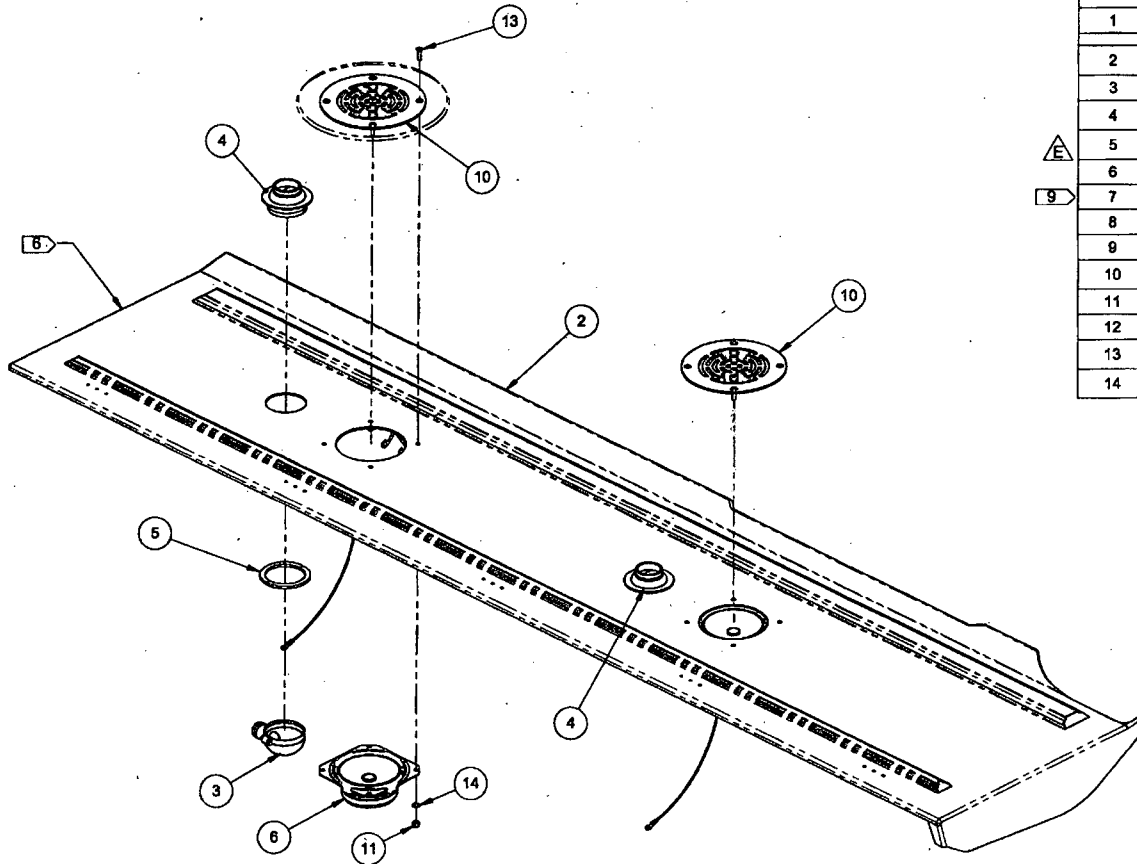
8x

Thursday, January 23, 2014 8:26:26 AM

Shop Packet Print

Page 3

8 7 6 5 4 3 2 1



ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-142 ✓	RH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4648-1 ✓	PLENUM CAP ASSEMBLY
4	2	D4652-1 ✓	AIR VALVE
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-042	RH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-044	RH SPEAKER #2 HARNESS ASSEMBLY
10	2	D4743-1	SPEAKER GRILL
11	8	MS21044-N08	NUT
12	8	MS21919WDG8	CLAMP
13	8	MS24893-BB51	SCREW
14	8	NAS1149DN832J	WASHER

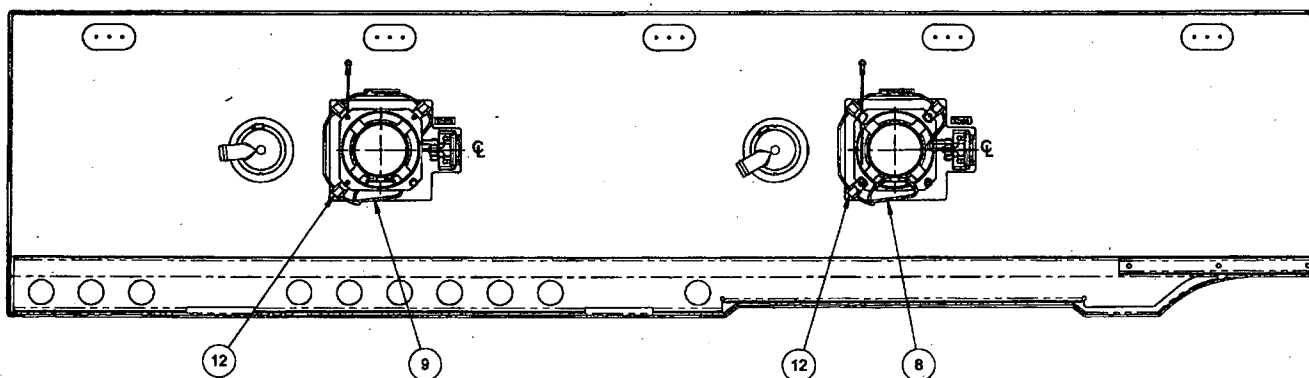
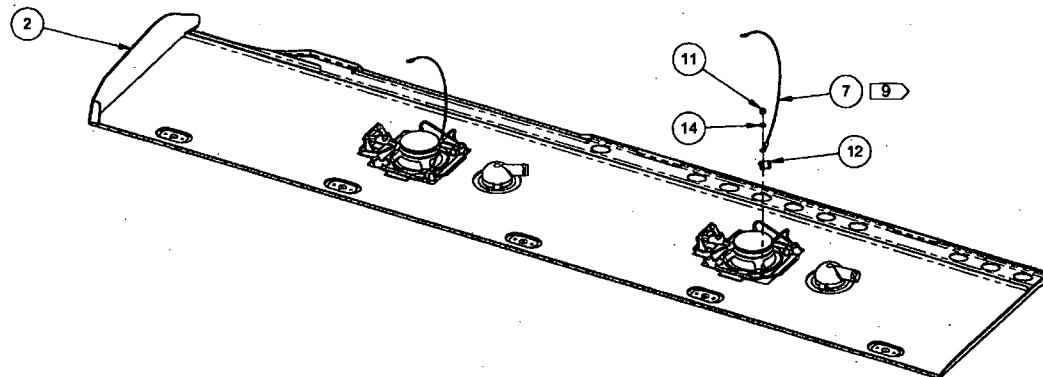
D4635-042 RH, FWD CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 8.0 lbs
- 8) INSTALL D4728-042/-044 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4635	SHEET 3 OF 18
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

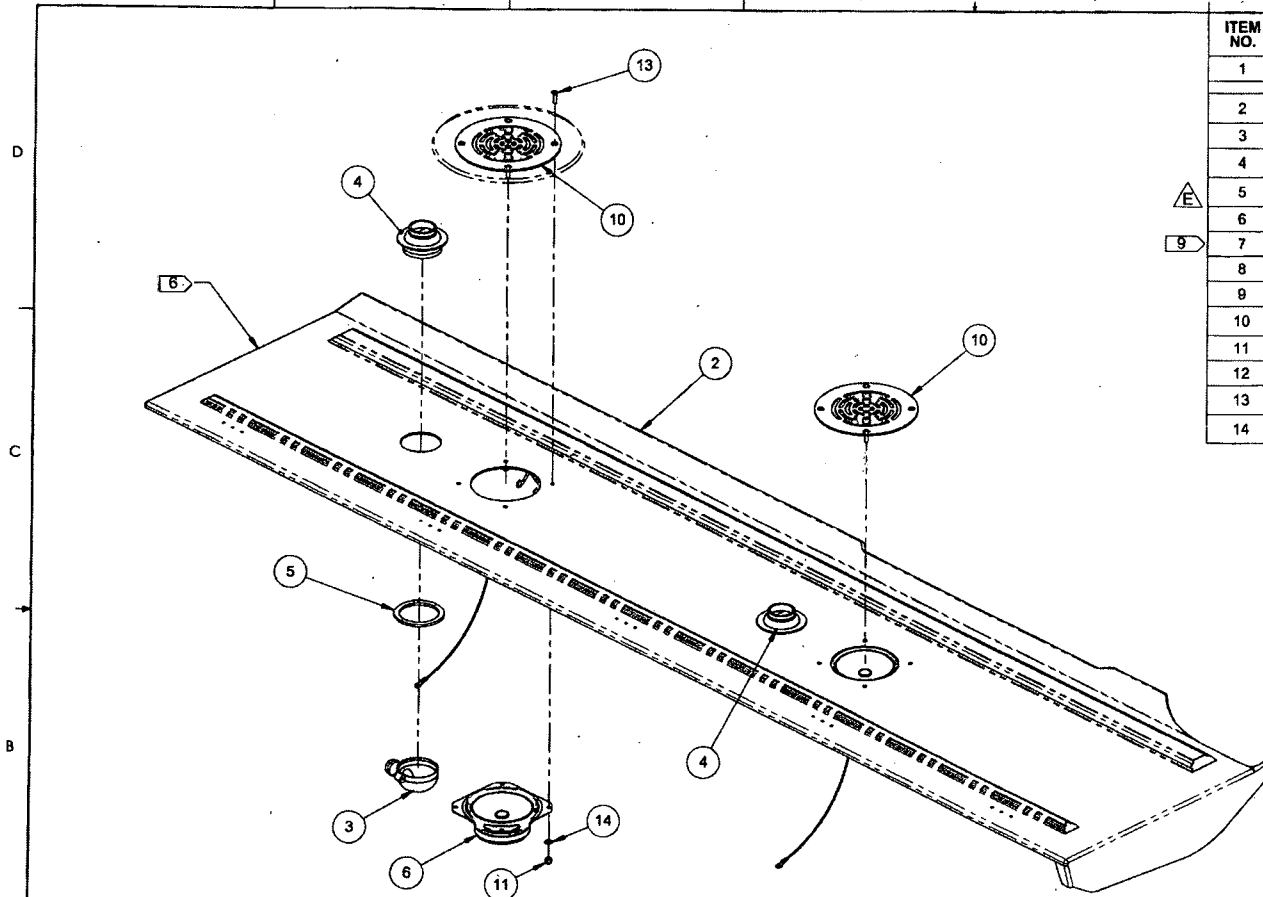


D4635-042 RH, FWD CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4635 TITLE OUTBOARD CEILING PANELS DATE 14.01.09	REV. E
DRAWN	RF		SHEET 4 OF 18
CHECKED	PC		SCALE
MFG. APPR.	PC		NTS
APPROVED	PC		
DE APPR.	PC	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

44-318261

8 7 6 5 4 3 2 1



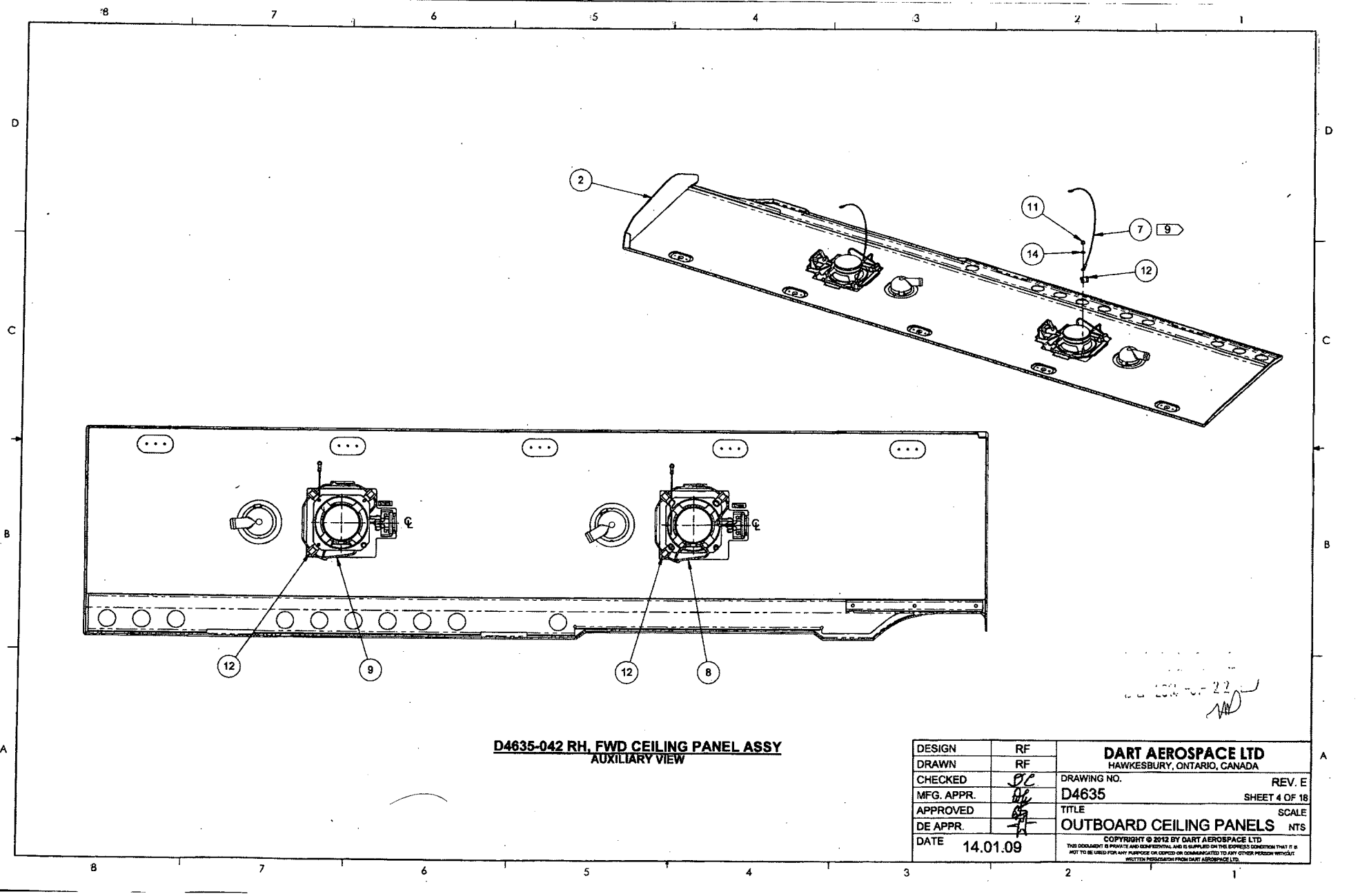
ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-042	RH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-044	RH SPEAKER #2 HARNESS ASSEMBLY
10	2	D4743-1	SPEAKER GRILL
11	8	MS21044-N08	NUT
12	6	MS21918WDG8	CLAMP
13	8	MS24693-BB51	SCREW
14	6	NAS1149DN832J	WASHER

D4635-042 RH, FWD CEILING PANEL ASSY

- NOTES:**
 1) MATERIAL: N/A
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4635	SHEET 3 OF 18
APPROVED	BC	TITLE	SCALE
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8 7 6 5 4 3 2 1



D4635-042 RH, FWD CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO.	SHEET 4 OF 18
MFG. APPR.	<i>PC</i>	D4635	
APPROVED	<i>PC</i>	TITLE	SCALE
DE APPR.	<i>PC</i>	OUTBOARD CEILING PANELS	NTS
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